

Date: Tuesday, 10/23/2007 3:11:18 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ASPIRATOR ASSEMBLY
Job Number : 35329 - 1
Estimate Number : 10480
P.O. Number :
This Issue : 10/23/2007 S.O. No. :
Prsht Rev. : NC Part Number : D2410
First Issue : 1 / Type : SMALL /MED FAB Drawing Number : D2410
Previous Run : 26895 Project Number : N/A
Material :
Due Date : 11/10/2007 Drawing Revision : A1
Qty: 4 Um: Each
Written By :
Checked & Approved By :
Comment : Est: C 09/04/14 Reformat; Incorporated D2292;
D2375-3-08-106; D2403 - D2417 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2375308 Insulation 48'of 3"ID*1/



Comment: Qty.: 0.8333 f(s)/Unit Total : 3.3332 f(s)
Insulation 48'of 3"ID*1/

Pick:

Qty Part Number Description Batch
10.6" D2375-3-08 Insulation 1810

FF 07-11-15

2.0 D2403 Outer Skin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Outer Skin

Pick:

Qty Part Number Description Batch
1 D2403 Outer Skin 35333

35015 FE 07-11-15

3.0 D2404 Perforate Sheet, 0.125 Ho



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Perforate Sheet, 0.125 Ho

Pick:

Qty Part Number Description Batch
1 D2404 Perforated Sheet 35803

FF 07-11-15

4.0 D2411 Valve support, 5052-H34



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Valve support, 5052-H34





Pick:

Qty Part Number Description Batch
1 D2411 Valve Mtg Angle 324399

7-11-1558

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/11/13		ADD A QC #5 to split up assembly. to have H ^{extra} a extra inspection to inspect be for D2375-3-08-106 (Insulation) and D2403 (outer skin) is riveted on the assembly				07-12-13	07/11/13	

Part No: D2410 PAR #: NA Fault Category: Prod / FAB ASS ^{needed small} NCR: Yes No DQA: D Date: 08/02/14
 QA: N/C Closed: 10 Date: 08 02 14

NCR: 35329		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/19	# 30/ 190	Perforated sheet D2404 - Rolled+cut wrong way (4x) RC Human error		Scrap and Destroy and Replace	FF 07/11/19			

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Job Number: 35329

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2412

Insulation filter



Comment: Qty.: 0.7673 sf(s)/Unit Total: 3.0692 sf(s)

Insulation filter

Pick:

Qty

Part Number

Description

Batch

110.5si

D2412

Insulation Filter

B31028

FF 07-11-19

(4)

6.0

D2413

Intake Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Intake Weldment

Pick:

Qty

Part Number

Description

Batch

1

D2413

Intake Assembly

35335

FF 07-11-16

(4)

7.0

D2414

Outlet Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Outlet Weldment

Pick:

Qty

Part Number

Description

Batch

1

D2414

Outlet Assembly

3
B21844

V SP
35336

8.0

D2416

Mounting angle, 1x.625x.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty

Part Number

Description

Batch

1

D2416

Mounting Angle

B24398

SP B 35960

FF 07-11-29

4

9.0

D2417

Mounting angle, 1x.625x.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty

Part Number

Description

Batch

1

D2417

Mounting Angle

B24398
B24398

B 35960
B24398 (4x) FF 07-11-28

7-11-15 SP

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ FAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 35329

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet, Universal Head

Pick:

Qty

Part Number

Description

Batch

8

MS20470AD4-5

Rivet

M104156

SP

11.0

MS20600AD4W2

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

Pick:

Qty

Part Number

Description

Batch

8

MS20600AD4W2

Rivet

(or CR9163-4-2)

M4747

SP

(P10) →

12.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Cherry Rivets

Pick:

Qty

Part Number

Description

Batch

2

MS20600AD4W3

Rivet

(or CR9163-4-3)

M18071

SP

13.0

MS20600AD4W4

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Rivets

Pick:

Qty

Part Number

Description

Batch

12

MS20600AD4W4

Rivet

(or CR9163-4-4)

M105792

38
M105953

7-11-1550

(4x)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2410

FF 07-12-11 3
FF 08-02-06 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2410 PAR #: NA Fault Category: Red / Pass mod & small NCR: (Yes) No DQA: D Date: 08/02/14
 QA: N/C Closed: _____ Date: _____

NCR: <u>35329</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.11.11	12.0	3 parts, the stems kept pulling out of the rivet. upon drilling out the rivet, the hole slightly oversized.	<i>[Signature]</i> 07/11/21	Use CR 3213-4-03 CR 3213-4-03 in 14477 rivet as a substitute. Acceptable	<i>[Signature]</i> 07/11/21	<i>[Signature]</i> 07/11/21	<i>[Signature]</i> 07/11/21	<i>[Signature]</i> 07/11/21
07.12.07	14	Steam pulled out during Riveting. Attention error	<i>[Signature]</i> 07.12.04	Change to CR 3213-4-03 CR 3213-4-03 (Drill to suit 4.125") & drill to fit rivet.	<i>[Signature]</i> 07/11/21	<i>[Signature]</i> 07/12/04	<i>[Signature]</i> 07.12.04	<i>[Signature]</i> 07/12/07
		Change Quantities as indicated	<i>[Signature]</i> 07/11/21	MS 20600 AD4W3-14 MS 20600 AD4W4-2 Permanent Change	<i>[Signature]</i> 07/11/21	<i>[Signature]</i> 07/12/12	<i>[Signature]</i> 07/12/12	<i>[Signature]</i> 07/12/12

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Job Number: 35329

Part Number: D2410

Job Number:



Seq. #:

Machine Or Operation:

Description :

(Pb) →

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/07 (Y3)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

****Place masking tape on red anodize tube of flare section and access to interior of both ends.****

FL 08/02/08 (3)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FF 08-02-11 (3)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 08-02-11 (3)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.13

Job Completion



08/24/11 (3)

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2410 PAR #: N/A Fault Category: Prod/Ins. PSS med & small NCR: Yes No DQA: D Date: 08/02/14
 QA: N/C Closed: _____ Date: _____

NCR: <u>35329</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/27	4	COUNTERSINK hole in D2414 Put in Rivet (R3212-5-4) (m 106321) MADE NEW D2403/B35015 Drilled holes into new one To replace damaged one		Destroyed old D2403 Replaced with new one FF.	07/11/27 FF.	07/11/27	07/11/27	07/11/27
		3 assembly's have rivets that are installed incorrectly. RL Hammer error		Drill out all rivets for the outer tube (16) and Remove D2403 and D2375-3-08-106	FF 08-02-05	08/02/05	08/02/05	08/12/13
				Remove the rivets that were installed incorrectly	FF 08-02-05	08/02/05	08/02/05	08/12/13
				Inspect by QC	N/A	08/02/05	08/02/05	08/12/13
				Reinstall the rivets with new Rivets m# M520600AD 4-3 B# 10621 QTY 9	FF 08/02/05	08/02/05	08/02/05	08/12/13
				Reinspect QC	N/A	08/02/05	08/02/05	08/12/13
				Reinstall D2375-3-08-106 and D2403.	FF 08/02/06	08/02/06	08/02/06	08/12/13

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2410	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 ASPIRATOR ASSEMBLY	SCALE
A	95.04.06	NEW ISSUE	
A1	KT 03.04.29	ADDED FLARE	

RELEASED
1669/10 BW

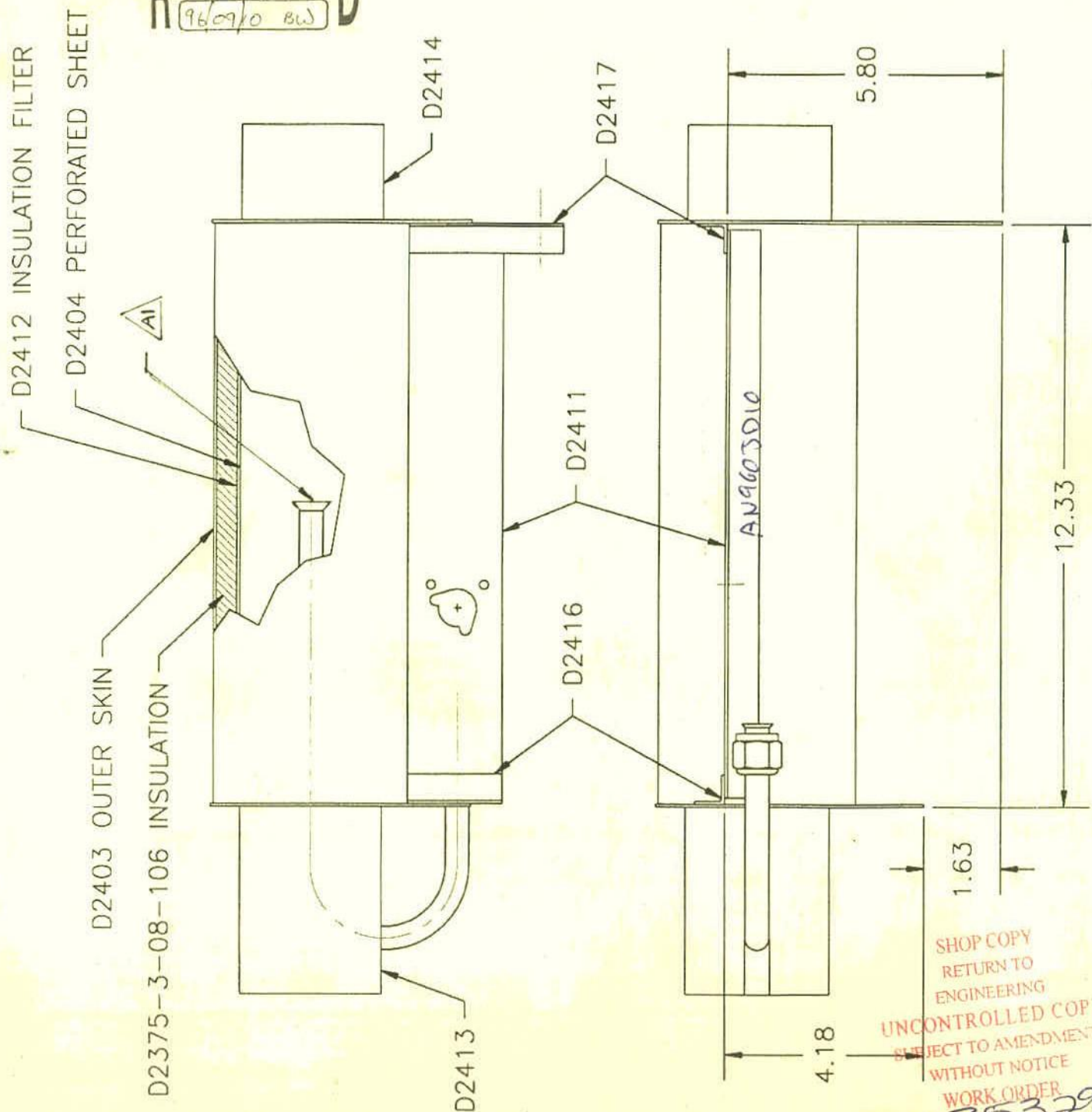
QTY	Part No.	Description
X	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS20600AD4W2	RIVET (CR 9163-4-2)
6	MS20600AD4W3	RIVET (CR 9163-4-3)
12	MS20600AD4W4	RIVET (CR 9163-4-4)
8	MS20470AD4.5	Rivets

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PREPARED		DART AERO ACCESSORIES INC	
B. Williams		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	D2410	REV. A
BW	BW		SHEET 2 OF 2
DATE		TITLE	SCALE
Apr. 6, 1995		206 ASPIRATOR ASSEMBLY	

RELEASED
9609/0 BW



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